

BLUE

Date: Wednesday, 03/09/2008 11:31:23 AM  
User: Julie Lecocq

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	HELI ACCESS STEP RH
<b>Job Number</b> :	41784		
<b>Estimate Number</b> :	11764		
<b>P.O. Number</b> :		<b>Part Number</b> :	D206628022BL
<b>This Issue</b> :	03/09/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	N/A - BLUE
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	39838	<b>Drawing Revision</b> :	N/A
	<b>Type</b> :	<b>Material</b> :	
	LARGE FAB ASSY	<b>Due Date</b> :	26/09/2008
<b>Written By</b> :		<b>Qty:</b>	2
<b>Checked &amp; Approved By</b> :	JUD 08.9.03	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:D as per ECN 766 JLM Est Rev:E as per ecn 1118 DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-022 CHG 002

4/9/08

8 08/09/08

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

3.0	41784A	206L/407 STEP ASSY, RH
-----	--------	------------------------



**Comment:** Sub-Component Step Assembly

1 x D2724-042 Batch 41784A 50

4.0	D2732030	Rubber Cushion
-----	----------	----------------



**Comment:** Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Rubber Cushion

batch 1337632

4 feet

50

5.0	AN414A	Bolt
-----	--------	------



**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch M107534

8/9/04

x2

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 11:31:23 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP RH

Job Number: 41784

Part Number: D206628022BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D27317

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 BLUE Mounting Lug

41720

8/9/05

SD

7.0

D3394043

Lug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-043 BLUE LUG ASS,Y

41711

8/9/05

SD

8.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN4-15A Bolt

M108071

SD

9.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN960JD416 Washer

M108161

SD

10.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21042L4 Nut (or MS21042-4)

M107499

8/9/04

SD

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/8/05 2 RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 11:31:23 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP RH

Job Number: 41784

Part Number: D206628022BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-022

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

Rev G

JS 08/09/29 (x2)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

D 08/09/26

MF 08-09-25

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 11:31:23 AM  
User: Julie Leacock

## Process Sheet

Customer : CU-FAR001 Dart Helicopters Services Drawing Name : HELI ACCESS STEP RH  
Job Number : 41784  
Estimate Number : 11764  
P.O. Number :  
This Issue : 03/09/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D206628022BL  
First Issue : / / Type : LARGE FAB ASSY Drawing Number : N/A - BLUE  
Previous Run : 39838 Project Number : N/A  
Material :  
Due Date : 26/09/2008 Qty: 2 Um: Each  
Written By :  
Checked & Approved By : JUD 08.9.03  
Comment : Est Rev:D as per ECN 766 JLM  
Est Rev:E as per ecn 1118 DD verified by:EC

## REFERENCE ONLY

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JUD 08.9.16



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-022 CHG 002

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 41784A 206L /407 STEP ASSY, RH



Comment: Sub-Component Step Assembly

1 x D2724-042 Batch

4.0 D2732030 Rubber Cushion



Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s)

Rubber Cushion

batch

5.0 AN414A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch

BLUE 628.022

Dart Aerospace Ltd.

Date: Wednesday, 03/09/2008 11:31:29 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L /407 STEP ASSY, RH
Job Number	: 41784A		
Estimate Number	: 11703		
P.O. Number	:	Part Number	: D2724042
This Issue	: 03/09/2008 S.O. No. :	Drawing Number	: D2724 REVC
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 39838A	Material	:
Written By	:	Due Date	: 26/09/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>JLD 08.9.03</u>		
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2622120C	Step Extrusion
-----	-----------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty	Part #	Description	Batch:
-----	--------	-------------	--------

1	D2622-120C	Extrusion	B40937
---	------------	-----------	--------

Check Material for any Dents or Defects

SP 08.09.04 (2x)

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724

Deburr and bevel ends for welding

SP 08.09.04 (2x)

3.0	D2734	Step End Plate
-----	-------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: 206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	339179

SP 08.09.08 2

4.0	D34581	Step Mounting Plate
-----	--------	---------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	336408

SP 08.09.08 2



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 11:31:29 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 41784A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

336409

SE 08.09.08 2

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch: M108031

M108350

Grind end cap welds flush

SE 08.09.08 2

7.0

QC9

VISUAL WELDING INSPECTION



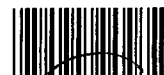
Comment: VISUAL WELDING INSPECTION

BE  
Cp 08-09-15

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/15 (2R)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08/09/15

(2)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M/A 08/09/15

(2X)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

SP 08.09.16

(10X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 11:31:29 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/407 STEP ASSY, RH

Job Number: 41784A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: 108037

Grind end plate flush.

SAD 08/09/17 (2)

SP 08.09.16 (2x)

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-09-17 (2)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/17 (2x)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

(2x)

Touch up Alodine

M. 08/09/17

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

B106729

-SPRAY PAINT DELFLEET BLUE

B105918

-CLEAR DELFLEET

B109333

ml 08 09 23

(2)

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

S 08/09/25

(2x)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5.4.4

M109219

08-09-25 (2x)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/09/25 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 03/09/2008 11:31:29 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 41784A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PPP -41784

JS 8/09/25 (x2)

20.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

D 08/09/26

Job Completion



mf 08-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

RELEASED  
05.11.14

APPLY BLACK  
ANTI-SKID ON  
TOP SURFACE  
TO BOTTOM  
OF TOP RADIUS

- REFER TO STEP  
END DETAIL

D2724-1  
MAKE FROM EXTRUSION D2622-107

D2724-041 LH STEP ASSEMBLY (SHOWN)  
D2724-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO  
MATCH BEND RADIUS OF END PLATE

**D2721-041/-042 STEP ASSEMBLY PARTS LIST**

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622 TYPICAL S  
2) WELD PER DART QSI 004 NOT  
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4  
4) ALL DIMENSIONS ARE IN INCHES  
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

TYPICAL STEP END DETAIL  
NOT TO SCALE

D2734 END PLATE

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.		REV. C
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D2724	SHEET 1 OF 1
DATE	05.09.19			TITLE	206L/407 STEP ASSEMBLY	
A		97.12.04		NEW ISSUE		
B		98.10.19		UPDATED WELD DETAIL REVISED TOLERANCES		
C		05.09.19		RE-DESIGN, ADD D3458-1/-3		

Copyright © 2005 by DART AEROSPACE USA, INC.

Copyright © 2005 by DART AEROSPACE USA, INC

## ENGINEERING

UNCONTROLLED COPY

~~SUBJECT TO AMENDMENT~~

WITHOUT NOTICE

WORK 95277

NO